

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009131**Date Inspected:** 09-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lvli Qing, Wan Wen Zhong**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY #14

This QA Inspector randomly observed the following work in progress

FCAW welding process of weld joint 056 located on PCMK SEG052B. Welder is identified as 044774ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U4B-F.

FCAW welding process of weld joint 020 located on PCMK SEG062B. Welder is identified as 214945ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-TC-U4B-F.

FCAW welding process of weld joint 13 located on PCMK SSD16-PP92. Welder is identified as 055641ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

FCAW welding process of weld joint 130 located on PCMK SSD16A-PP92. Welder is identified as 055491ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply

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with the WPS-B-T-2233-B-U2-F.

SAW welding process of weld joint 004 located on PCMK DP538A. Welder is identified as 045265ZPMC QC is identified as Liu Wan Ning. The welding variables recorded by QC appeared to comply with the WPS-B-P-2221-B-L2C-S-2.

SMAW welding process of weld joint 027 located on PCMK SSD14-PP79. Welder is identified as 205718ZPMC QC is identified as Liu Wan Ning. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4B.

FCAW welding process of weld joint 125 located on PCMK SSD13-PP85. Welder is identified as 201215ZPMC QC is identified as Liu Wan Ning. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

FCAW welding process of weld joint 126 located on PCMK SSD13-PP85. Welder is identified as 202122ZPMC QC is identified as Liu Wan Ning. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

BAY#10

This QA Inspector randomly observed the following work in progress

FCAW welding process of weld joint 4 located on PCMK SSTL3-1D/K. Welder is identified as 040533 ZPMC QC is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P5-F.

FCAW welding process of weld joint 5 located on PCMK SSTL3-1D/K. Welder is identified as 053869 ZPMC QC is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P5-F.

FCAW welding process of weld joint 2A located on PCMK NSD1-SPSA3. Welder is identified as 040343 ZPMC QC is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-F.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 150-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer